

Date: Thursday, 5/22/2008 12:06:55 PM  
 User: Chantal Lavoie

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOOT  
 Job Number : 39397-2  
 Estimate Number : 13331  
 P.O. Number :  
 This Issue : 5/22/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D37871  
 First Issue : / / Type : PURCHASED PARTS Drawing Number : D3787  
 Previous Run :  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A 08-05-20 new issue DD verified by: LL

Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 5/26/2008 Qty: 24 Um: Each

*REV A* *PROTOTYPE*

## Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: Issue P/O: 6278  
 Purchase Part Number: MS22034-1B  
 Supplier: AUTO PARTS (P/N: 32334)  
 Certificate of conformity is required

C208/05/01

(24)

2.0 MS220341B Foot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)  
 FOOT

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Recieve & Inspect for Transit Damage  
 Ensure Material Release Note is attached

*PC 8/5/26* (2)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*PH 08-05-26* (2)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

*Drill* → 1-Open hole to finish size as per dwg D3787  
 2-deburr

*FF 08-05-28* (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 5/22/2008 12:06:55 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOOT

Job Number: 39397

Part Number: D37871

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*PH 08.05.28*



**ENGINEERING  
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

*208.05.28 (2)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

*PH 08.05.28*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*11 08.05.29 Prototype*

Job Completion



*11 08.06.10*

**POSITIVE RECALL**

EFFECTIVE *08.05.22* AUTH *4*  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

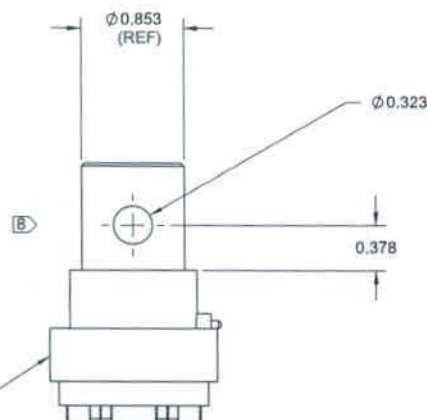
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

UP 08.05.06



MS22034-1B  
ADAPTER, QUICK DISCONNECT,  
PASSENGER SEAT TO FLOOR

# **D3787-1 FOOT**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.13 lbs
  - 8) DRILL: Ø 0.323 HOLE 0.378" FROM SHOULDER

REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.06		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3787** REV. A  
SHEET 1 OF 1

TITLE **FOOT** SCALE 1:1

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U208/05122  
W10: 39397







**AUTO PARTS • PIÈCES D'AUTO  
TRUCK PARTS • PIÈCES DE CAMION  
ENGINE-MARINE • MOTEUR-MARINE  
PERFORMANCE PARTS • PIÈCES DE PERFORMANCE  
TIRES • PNEUS**



Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.  
TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours, 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournable.  
TERMS: Compte payable le 10 du mois suivant

SIGNATURE \_\_\_\_\_

GST / TPS  
10035 3366 RT0001

1000 RUE LANDSDOWNE HAWKESBURY, ON K6A 1H7  
TEL: (613)632-1191 FAX: (613)632-2350

TVO  
1016330716 TQ0001

Gagner une des 10 paires de billets pour la course Nascar a Montreal le 1er et 2 aout. Informez-vous aupres de votre Representant Benson.

113336 (613)632-5200  
DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY ON K6A 1K7

113336  
\*\*\* SAME \*\*\*  
SHIP TO A

DATE: 5/26/08  
08:23  
111 MLP

PO: 00006278

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION
2	2	TWD>	KIN32334	jaw leg stud fitti	PA 01-0526	84.95	169.90
	2	***	= ms220341b	PIECES/CORE TOT	0.00		0.00
			SHIP VIA	REGULAR			
54 million							
INVOICE No / FACTURE	TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT to PAY / À PAYER
11877606	INVOICE	169.90	0.00	0.00	8.50	0.00	178.40

VERSUS BUSINESS FORMS (CORNWALL) (613) 936-1852





# DART

## Purchase Order

Date May 01, 2008	Page 1
Purchase Order Number PO00006278	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FAKED**  
6/28/09

**Vendor Address:**

Auto Parts Extra  
1000rue Lansdowne  
Hawkesbury, ON K6A 1H7  
Canada  
Phone (613) 632-1191  
Fax (613) 632-2350

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-AUT001	May 01, 2008	N30	yours	May 14, 2008

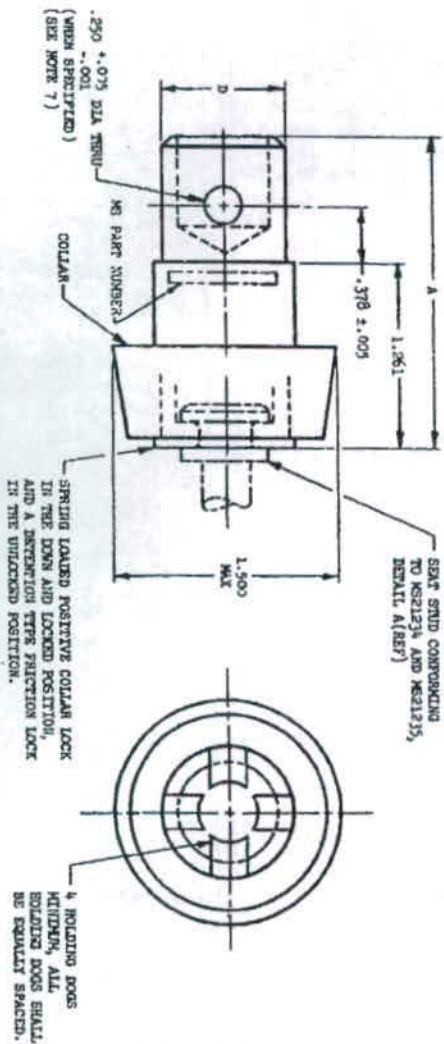
Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
24.0000	MS220341B	Foot Comments: JAW CHAIR LEG STUD FITTING (P/N: 32334 )	5/14/2008	No	7.079166	Each	169.90
<div>22 + 24 may.</div> <div>CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div>							
Comments: <i>Chantal</i>		Tax Summary:		Less:			
		GST		8.50		included tax	
		GSTME		0.00			
		GSTND		0.00			
		Entered By: <i>CL</i> CLAVOIE		Subtotal		169.90	
		Approved By: <i>W</i>		Total tax		8.50	
				Total purchase order in			
				CAD Dollars		178.40	



This military standard is approved by the Department of Defense and is mandatory for use by all Departments & Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

OTHER INTEREST:  
REVIEW USER  
AFMCI-WO NAVY-CG  
NAVY-WP  
AF-11,82

NOTICE - REVIEW/USER INFORMATION IS CURRENT AS OF DATE OF THIS DOCUMENT. FOR FUTURE COORDINATION OF CHANGES TO THIS DOCUMENT, DRAFT CIRCULATION SHOULD BE BASED ON THE INFORMATION IN THE CURRENT FEDERAL SUPPLY CLASSIFICATION LISTING OF DOD STANDARDIZATION DOCUMENTS.



DASH NO.	A HEIGHT	D DIA	WEIGHT MAX LB
-1		.855/.890	
-2	2.156	.885/.882	
-3		.867/.864	
-4		.792/.748	.25
-5	2.385 ± .015	.893/.890	
-6		.917/.914	

# NOTES:

1. MATERIAL: SEE PROCUREMENT SPECIFICATION.
2. FINISH: SEE PROCUREMENT SPECIFICATION.
3. REMOVE ALL BARRS AND SHARP EDGES.
4. CONTOUR OPTIONAL PROVIDED DIMENSIONS INDICATED ARE NOT EXCEEDED.
5. WHEN THE ADAPTER IS INSTALLED ON THE FLOOR STUD, THE DIAMETRAL CLEARANCE SHALL BE NOT GREATER THAN .040.
6. DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ± .010.
7. WHEN A MOUNTING HOLE IS REQUIRED, THE CENTERLINE OF THE HOLE SHALL COINCIDE WITH THE PROTECTED CENTER LINES OF ANY TWO OPPOSITE MOUNTING HOLES.
8. PART NUMBERS: A AND B AFTER DASH NO. FOR QUICK DISCONNECT ADAPTER WITHOUT MOUNTING ROLL.
9. EXAMPLES OF PART NUMBERS: MS22034-1 QUICK DISCONNECT ADAPTER .855/.890 DIA X 2.156 HIGH WITH MOUNTING ROLL. MS22034-1B QUICK DISCONNECT ADAPTER .855/.890 DIA X 2.156 HIGH WITHOUT MOUNTING ROLL.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BIDS.

## ① DOTTIE STANDARD REVISED

P.A. NAVY-WP Other Cui USAF-11 ARMY-WP	TITLE ADAPTER, QUICK DISCONNECT, PASSENGER SEAT TO FLOOR	MILITARY STANDARD MS22034
PROCUREMENT SPECIFICATION MIL-A-21165	SUPERSEDES	SHEET 1 OF 1

DD FORM 672-1 (Continued)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 1522C

APPROVED 25 NOV 57 REVISED (A) 27 AUGUST 65





## Jason Murdoch

**From:** Harvey Siemens [hsiemens@dartaero.com]  
**Sent:** May 27, 2008 9:19 AM  
**To:** 'Jason Murdoch'; 'Chris Provencal'  
**Cc:** 'David Shepherd'; 'Mike Petsche'  
**Subject:** RE: Prototype D3787

REFERENCE ONLY

Jason

I believe that the drawing meets the requirements of QSI043 6.3.10.1.1 – which indicates that a through hole is dimensioned with a diameter and that's it. However I will try to twist the iso view in the corner so that the user can see the other half of the hole.

In short – YES it is a thru hole.

Regards,

*Harvey Siemens*

Dart Aerospace Ltd  
Calgary, Alberta  
1-403-717-0328  
[hsiemens@dartaero.com](mailto:hsiemens@dartaero.com)

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**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** May 27, 2008 6:50 AM  
**To:** 'Chris Provencal'; 'Harvey Siemens'  
**Subject:** Prototype D3787

Good morning Fella's,

On the drawing, it is not clear as to whether the hole 0.323 is a through hole. I appears to me going by the assembly, that it should be, but the question was asked on the floor. Please add a note to the drawing for future clarification. And can I get a response on this to inform the employees?  
Thanks and have a good day.

Jason Murdoch

**Qc. Coordinator**  
[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)

27/05/2008

10-21-1944

10-21-1944

10-21-1944

10-21-1944

10-21-1944

10-21-1944

10-21-1944

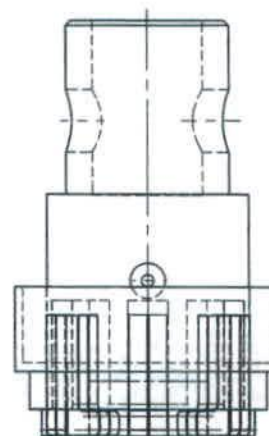
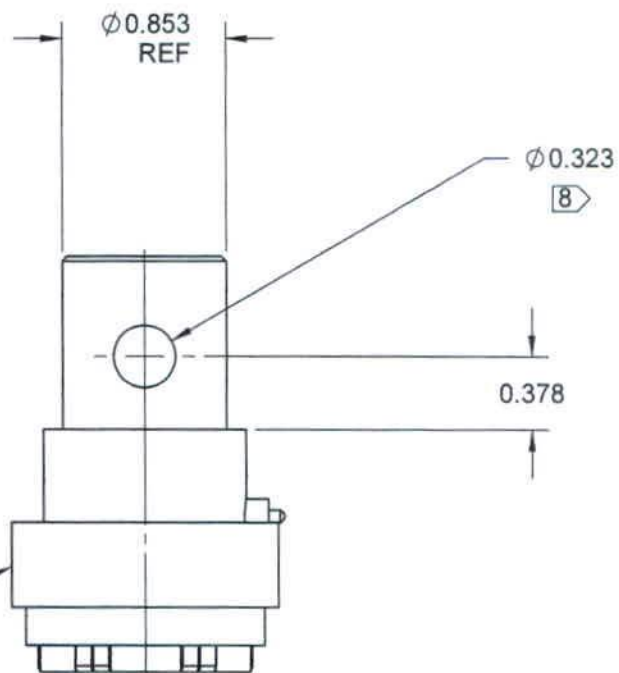
10-21-1944

10-21-1944

10-21-1944

10-21-1944

10-21-1944



REFERENCE ONLY

D3787-1 FOOT

A	NEW ISSUE	
REV.	DESCRIPTION	
DESIGN	HS	[
DRAWN	HS	
CHECKED		DRAWING

0.216

22034-1B  
CONNECT,  
O FLOOR

